March-19-13 10:53:39 AM 🚽 Item ID: 🕯 646.4001 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: AS350 Cable Cutter Start Date: 3/19/13 Start Oty: 1.00 \*1\* **Cust Item ID:** Required Date: 4/02/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: MC5 Date: 13-03-19 Tooling: **Approvals:** QC: \_\_\_\_\_ Date: \_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** 646.4000 Α 100 0.00 DOCUMENT CONTROL \*100\* Memo Document Control Photocopy bluefile & type labels per PPP 646.4001 110 Pick Kit 0.00 13-03-2248 \*110\* Packaging 0.00 Memo Packaging 120 QC4-100% Inspect kits for completeness 0.00 \*120\* QC 0.00 Memo Quality Control

										DQA:	Date:	:	
NCR: Y	es / No	)			WORK ORDER NON-C	CONFC							
										QA Closed:	Date:	· ·	
Nork Orde	er:				DISPOSITION				AGAINST DE	EPARTMENT/PROCESS			
Part No.					Rework Scrap	]	Skid-tube Crosstube Machining Small Fab			<del></del> }	Water Jet	Engineering Quality	
NCR N	lo				Use-as-is Work Order Update	]   Th	ermoformi Large F		Finishing Composite	Rec/Stor	re/Packaging Supplier	Other	
Root				Descr	iption of work order update	Initia	1	Act	tion	Sign &	1		
Cause	Date	Step	Qty		or Non-conformance	on-conformance Chief Eng Descri			ription	Date	Verification	QC Inspector	
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	Bendir	ng			Bend	Gra	in			Ovalized		Pressure/Forced	
	Centre	Not Conce	entric to	o/s	BOM/Route	Har	dware			Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Insp	ection Inco	mplete		Part Incorred	ct	Weld	
	Crushe	ed/Crimped	i		Burrs	Inst	ructions Inc	omplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
Cuffs Contamination						Ma	intenance			Part Moved	1		
Heat Treat Countersink						Mis	labeled			Positioned V	V <sub>r</sub> rong	_	
Inspection Strip in Tube Cur					Cut Too Short	Mis	read			Power Loss/	Surge	Other	
	Ripple	s in Bend			Drill Holes	Offs	et						
	Torque	e Waves in	Extrusio	n	Drawing	Out	Out of Calibration						

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wo	rk	Oi	rder	ID	98646
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\*98646\*

Page 2

March-19-13 10:53:39 AM Item ID: 646.4001 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: AS350 Cable Cutter Start Qty: 1.00 **Start Date:** 3/19/13 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 4/02/13 **Customer:** Reference: Run Process Plan: Date: Approvals: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 130 0.00 \*130\* Packaging Packaging 0.00 Memo Packaging Identify and pack for shipping as per PPP 646.4001 Location: 140 QC21- Final Inspection - Work Order Release 0.00 \*140\* MC5 13-04-16 MP, 4-16 QC 0.00 Memo Quality Control

NCR:	Yes	/	No

Date:

NCR: Y	es / No				WORK ORDER NON-	CONFOR	MANCE / UPI	DATE						
									QA Closed:	Date	·			
Work Orde	r:				DISPOSITION	AGAINST DEPARTMENT/PROCESS								
					Rework	]	Skid-tube	Crosstube		Water Jet	Engineering			
Part N	o				Scrap		Machining	Small Fab	-1	Prod. Eng. Coor. Quality  Rec/Store/Packaging Other				
NCD N	1_				Use-as-is	Theri	moforming	Finishing	——————————————————————————————————————					
NCR N	0				Work Order Update	J	Large Fab	Composite	j	Supplier				
Root	Root Descri				ption of work order update	Initial	Act	tion	Sign &	١				
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector			
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		ot Conce	ntric to	o/s	BOM/Route	Hardw		<u> </u>	Over/Under	. —	Temperature/Cure			
1	Cracks				Broken/Damaged	<b>⊢</b> ⊣ `	tion Incomplete		Part Incorre	· —	Weld			
		/Crimped			Burrs	<del></del>	tions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
	Cuffs			_	Contamination	<del></del>	enance		Part Moved					
	Heat Tre				Countersink	Mislab	,		Positioned V	, -	7			
	<del></del>	on Strip in	Tube	oxdapsilon	Cut Too Short	Misrea Offset	d	L	Power Loss/	Surge	Other 6			
	Ripples in Bend Drill Holes													
		Waves in 1		n L	Drawing	$\vdash$	Calibration			<del> </del>				
	<b>—i</b>	Sequence			Finish	Out of	Sequence			· .				
	Wave/T	wist in Tul	be		Folio	Outsid	e Dimensions							

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

March-19-13 10:53:42 AM

Work Order ID: 98646

\*98646\*

. Parent Item:

646.4001

\*646 4001\*

Parent Item Name: AS350 Cable Cutter

**Start Date:** 3/19/13

Required Date: 4/02/13

Page 1

Start Qty: 1.00

Required Qty: 1.00

IPP REV:A 12.10.23 NEW ISSUE DD VERE-ILM

	Comments:	PREV:A 12.10.	23 NEW ISSUE	DD	VERF:JLM										
	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date St Issued	atus	
5	646.3301 <b>646.3301</b> Upper Cutter Assembly	<u> </u>	Manufactured	No				Each	0.0000	**	1200	K3	Ċ	2	SHP
ζ	646.3001	*	Manufactured	No				Each	0.0000	**	120	783		S	Sim <sup>C</sup>
5	646.2910 <b>£646_2910</b> Deflector	*	Manufactured	No			·	Each	0.0000	**	120	U 8 3	G	/ /5	SH>
<u> </u>	646.3810 *646_3810 Bracket	*	Manufactured	No				Each	0.0000	**	293	320	/	, 5,	
5	646.3510 *646.3510 Strut	* 3#	Manufactured	No				Each	0.0000	**		12508	3 <i>(</i> _	2	WS.
/ 	646.3511 <b>*646-351-1</b> Strut	*	Manufactured	No				Each	0.0000	**	m12	0083	3 (	- 51	mD
/ )	646.3512 5646-3512 Strut	*	Manufactured	No				Each	0.0000	**	MI	20F3	C	Sm	P
/	646.3513	<b>*</b> 3.	Manufactured	No				Each	0.0000	**	Mia	ous3	(	24	η)

NICD.	V	•	RI.
NCR:	Yes	,	No

DQA: Date:

NCR: Ye	es / No				WORK ORDER NON-O	CONFO	RMANCE / U	PDATE	0.4.61	i .				
	<del></del>					4	QA Closed: Date:							
Nork Ordei	ŕ:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	Proc	Water Jet d. Eng. Coor	Engineering Quality			
NCR N	o				Use-as-is Work Order Update	Th	ermoforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other			
Root				Descri	ption of work order update	Initia	1 /	Action	Sign &					
Cause	Date	Step	Qty	(	or Non-conformance	Chief E	ng De	scription	Date	Verification	QC Inspector			
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<u> </u>	Centre N	lot Conce	ntric to (	o/s	BOM/Route	<b>—</b>	dware		Over/Under	<del></del>	Temperature/Cure			
_	Cracks Broken/Damaged				<b>—</b>	ection incomplete	<u> </u>	Part Incorred	: <b>—</b>	Weld				
1	Crushed/Crimped Burrs				$\blacksquare$	ructions Incomplete	e/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled				
L	Cuffs Contamination					$\vdash$	ntenance	L	Part Moved					
L	Heat Treat Countersink					Mis	abeled	L	Positioned W		7			
	_	on Strip in	Tube		Cut Too Short	Mis		L	Power Loss/	Surge	Other			
	Ripples i	n Bend			Drill Holes	Offs								
	Torque Waves in Extrusion Drawing						Out of Calibration							
	Turning	Sequence			Finish	Out	Out of Sequence							
	Wave/Twist in Tube Folio						side Dimensions							

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March-19-13 10:53:42 AM

Work Order ID: 98646

, Parent Item:

646.4001

Parent Item Name: AS350 Cable Cutter

\*98646\* \*646 4001\*

Location

**Start Date: 3/19/13** 

Required Date: 4/02/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

Each 10.454.00

\*\*

70

\*NAS4449E0332P\*

Location	<u>n</u>	Loc Qty	Loc Code
GA		182	
	122063	182	
ST294		269	
	122063	269	
ST295		3	
	123352	3	
st510		10000	
	123900	10000	
		Each	6,287.000
			**

MS21042L3

Purchased

No

Loc Code Loc Qty

4000

FP001	3
122141	3
GA	212
122452	212
ST314	268
117885	32
119017	55
119075	138
123265	43
ST506	5804
123900	1804

124291

13-03-22

NCR: Y	'es /	No				WORK ORDER NON	-COI	NFORM	MANCE / UP	<u> </u>	DQA: QA Closed:	Date:	10 of 11 = 120
Nork Orde	r:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	•
Part N NCR N	 lo		-			Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Small Fab Finishing	<b>⊸</b> i	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other	
Root					Descr	ription of work order update		nitial	Act	tion	Sign &		
Cause	D	ate	Step	Qty		or Non-conformance		ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator Material etup other rocess upplier raining													
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Landir	ng Gear				_	General	_	7		_	_		\$ } 4 % \\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence				,	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence			Ovalized Over/Under Part Incorred Part Lost/Mid Part Moved Positioned W Power Loss/S	ssing /rong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Tor Tur	que Waning Se	aves in E		n	Drawing		Out of Out of S					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

March-19-13 10:53:42 AM

Work Order ID: 98646

\*98646\*

. Parent Item:

646.4001

\*646 4001\*

Parent Item Name: AS350 Cable Cutter

**Start Date:** 3/19/13

Required Date: 4/02/13

Start Qty: 1.00

Required Qty: 1.00

646.3110 Manufactured Each 10.0000 \*\*

			Location	Loc Qty	Loc Code	
			ST139B	10		00016
646.3710 *646.3710*	Manufactured	No	92768	10 Each	0.0000	** 97198 SMP
Doubler 646.3210 *646.3210*	Manufactured	No		Each	0.0000	** 972488 // Sm
Support 646.3713	Manufactured	No		Each	0.0000	** 593208 SW
Gusset MS24694-S51  *MS24694-S51	Purchased	No		Each	196.0000	
Screw			<u>Location</u>	Loc Qty	Loc Code	** 5M
			ST303 116805 123741	196 1 195		12374

/ AN3-13A	
S-*AN	3=13A*
Bolt	

Purchased No Each 106.0000 \*\*

123741	
CINX	
$\sim$ 28	13-03-22
79	

Location	<u>n</u>	Loc Qty	Loc Code
ST351		56	
	104746	26	
	120910	30	
ST512		50	
	123759	50	

March-19-13 10:53:42 AM

**Shop Packet Print** 

Page 3

NCR:	Yes	/	No	WORK

# **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

TTOIL.	cs / 110				WORK ORDER ROW				QA Closed:	: Date	:
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	•
Part N					Rework Scrap Use-as-is	- I	Skid-tube Machining moforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	0				Work Order Update	] [ """	Large Fab	Composite	Recyston	Supplier	
Root				Descri	iption of work order update	Initial	Ac	ction	Sign &		
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Inapproved										1	
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1	Bending				Bend	Grain			Ovalized	The second of the	Pressure/Forced
L	Centre I	Not Conce	ntric to	o/s	BOM/Route	Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorred	ct _	Weld
	Crushed	/Crimped			Burrs	Instruc	tions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Movèd	1	
	Heat Tre	eat			Countersink	Mislabe	el <b>ed</b>		Positioned V	Vrong	
	Inspecti	on Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/		Other
•	Ripples	in Bend			Drill Holes	Offset					
Ţ	<b>—</b>	Waves in I	Extrusio	n	Drawing	Out of	Calibration			September 1	
Ţ	<b>—</b> 1 '	Sequence			Finish	Out of	Sequence			1	
l l	<b>⊣</b>	wist in Tul			Folio	Outside	e Dimensions			Í	

March-19-13 10:53:42 AM

Work Order ID: 98646

. Parent Item:

646.4001

Parent Item Name: AS350 Cable Cutter

\*98646\*

No

No

No

No

Purchased

Purchased

Purchased

Manufactured

\*646 4001\*

Required Date: 4/02/13 **Start Date:** 3/19/13 Start Qty: 1.00 Required Qty: 1.00 651.0000 \*\*

<u>Location</u>	Loc Qty	Loc Code		٠.
ST350	318			
120308	80			•
122814	38			
124858	200			
ST512	333			
120770	200			
123900	133		123700	
	Each	300.0000		_
		**	75	Sin
Location	Loc Oty	Loc Code		

Each

L	*CR3213=5=3* Cherry Rivet
)	CR3213-5-03

<b>Location</b>	Loc Qty	Loc Code
ST329	300	
123785	300	
	Each	813.0000
		**

12364	8	
<b>5</b> 8	JB	_j_

*MS204704D5=5.5*
Rivet

<b>Location</b>	Loc Qty	Loc Code	
ST336	813		
123425	813		
	Each	0.0000	
			**
	Each	0.0000	



Clip 646.3712

MS20470AD5-5.5

646.3711

Manufactured

NCR:	Yes	/	No

### **WORK ORDER NON-CONFORMANCE / UPDATE**

NCR: Y	es	/ NO				WORK ORDER NON-	CON	IFORN	MAINCE / UP	DATE	QA Closed:	Date	:
Nork Orde	r:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Part N	_					Rework Scrap		r	Skid-tube Machining	Crosstube Small Fab	-4	Water Jet	Engineering Quality
NCR N	lo					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root					Descr	iption of work order update	I	nitial	Act	tion	Sign &	r	
Cause	$\bot$	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
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Landir	ng G	ear				General					-		
		Bending				Bend		Grain			Ovalized	<u> </u>	Pressure/Forced
		Centre No	t Concer	ntric to (	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
ļ		Cracks				Broken/Damaged			on Incomplete		Part Incorred	<b>├</b>	Weld
	_	Crushed/C	Crimped			Burrs	$\perp$	1	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination	ļ	Mainte		_	Part Moved	· ·	
		Heat Trea			<u> </u>	Countersink	<u> </u>	Mislabe		<u> </u>	Positioned V	Vrong ∴ r:-	Other
	-	Inspection		Tube	<u> </u>	Cut Too Short		Misread	l		Power Loss/	Surge	Other
		Ripples in			<u> </u>	Drill Holes	$\vdash$	Offset				<del> </del>	
	_	Torque W		xtrusio	n  _	Drawing	<u> </u>		Calibration				The second second
	_	Turning Se	-		<u> </u>	Finish		i	Sequence			·	
	- 1	Wave/Twi	ist in Tuk	e e		Folio	1	Outside	Dimensions				•

March-19-13 10:53:42 AM

Work Order ID: 98646

\*98646\*

. Parent Item:

646.4001

\*646 4001\*

Parent Item Name: AS350 Cable Cutter

**Start Date: 3/19/13** 

Required Date: 4/02/13

Start Qty: 1.00

Required Qty: 1.00

646.3811 AN3-6A

Manufactured

No

Each

0.0000

\*\*

Purchased

Each 483,0000

\*\*

Location Loc Qty Loc Code ST350 300 124296 300 ST351 61 117441 34 121166 13 122993 10 123831 4 ST512 122 122814 122

MS24694-S55 Screw

Purchased

Manufactured

No

No

Each 119.0000

\*\*

Location Loc Qty Loc Code ST303 119 123758 124296 118 Each 0.0000 \*\*

Manufactured No 0.0000 Each

\*\*

24296

646.3610

Filler 646.3714

′es	/ No				WORK ORDER NON-	·CON	VFORM	MANCE / UP	DATE			
					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
lo lo			<del></del>		Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite				· · · —	Engineering Quality Other
T				Descri	ption of work order update	T i	nitial	Ac	tion	Sign &		
	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
						FAUL	T CATE	GORY				
ng G	iear				General					_		
	Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in	Crimped it n Strip in i Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Hardwa Inspecti Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ enance eled	Unclear	Part Incorre Part Lost/M Part Moved Positioned V	tolerance ct issing  Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
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Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date  Date	Date Step  Date Step  Date Step  Date Step  Date Step  Date Step  Date Step  Date Step  Date Step  Date Step	Date Step Qty  Date Step Qty  Date Step Oty  Bending Centre Not Concentric to C Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	Date Step Qty  Date Step Qty  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  Description  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Treat Countersink Inspection Strip in Tube Rework Scrap Use-as-is Work Order Update Strip in Scrap Oty Or Non-conformance Character Scrap Oty Or Non-conformance Character Scrap Oty Or Non-conformance Character Scrap Oty Or Non-conformance Character Scrap Oty Oty Oty Oty Oty Oty Oty Oty Oty Oty	DISPOSITION  Rework Scrap Use-as-is Work Order Update  Date Step Qty Description of work order update or Non-conformance  FAULT CATE  Gear General  Bending Gear General  Bending Centre Not Concentric to O/S BOM/Route Cracks Broken/Damaged Inspection of Scrip in Tube Countersink Mislabet Inspection Strip in Tube Cut Too Short Misread Ripples in Bend  Disposition  Rework Scrap Use-as-is Therm  Nork Order Update Initial Chief Eng  FAULT CATE  Therm  Rework Scrap Use-as-is Therm  Scrap Use-as-is Therm  Rework Scrap Use-as-is Instituted  Scrap Use-as-is Therm  Scrap Use-as-is Initial Chief Eng  Initial Chief Eng  FAULT CATE  Therm  Scrap Use-as-is Initial  Chief Eng  FAULT CATE  Therm  Scrap Use-as-is Initial  Chief Eng  FAULT CATE  Therm  Scrap Use-as-is Initial  Chief Eng  FAULT CATE  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  To Scrap Use-as-is Initial  Chief Eng  FAULT CATE  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm  Therm	DISPOSITION Rework Scrap Use-as-is Work Order Update Initial Chief Eng Description of work order update Chief Eng Description of work order update Step Qty Or Non-conformance Chief Eng Description of work order update or Non-conformance Chief Eng Description of work order update or Non-conformance Chief Eng Description of work order update or Non-conformance Chief Eng Description of work order update or Non-conformance Chief Eng Description Or Non-conformance Chief Eng Description Or Non-conformance Chief Eng Description Or Non-conformance Chief Eng Description Or Non-conformance Chief Eng Description Or Non-conformance Chief Eng Description Or 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 Description    Bending   Grain   Hardware   Hardware   Instructions Incomplete   Inspection Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   Instructions Incomplete   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Incorre Crushed/Crimped Instructions Incomplete Part Lost/M Alintenance Part Moved Heat Treat Countersink Mislabeled Positioned Inspection Strip in Tube Cut Too Short Mislabeled Power Loss/Ripples in Bend  DISPOSITION  AGAINST DEPARTMENT  Skid-tube Crosstube Machining Small Fab Pro  Thermoforming Finishing Small Fab Pro  Thermoforming Finishing Small Fab Pro  Thermoforming Small Fab Pro  Thermofo	WORK ORDER NON-CONFORMANCE / UPDATE  QA Closed: Date:  DISPOSITION  Rework Scrap Use-as-is Work Order Update Initial Action Composite Supplier  Date Step Qty Description of work order update Or Non-conformance Chief Eng Description Date Verification  FAULT CATEGORY  General Bending General Bending Centre Not Concentric to O/S Cracks Broken/Damaged Instructions Incomplete Inspection Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Inspection Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete 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Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

March-19-13 10:53:42 AM

Work Order ID: 98646

\*98646\*

. Parent Item:

646.4001

\*646 4001\*

Location

ST336

Parent Item Name: AS350 Cable Cutter

**Start Date:** 3/19/13

Required Date: 4/02/13

Start Qty: 1.00

Required Qty: 1.00

MS20470AD5-6

Purchased

No

No

No

Each 1,836.000

\*\*

105433

\*M\$\$0470AD5-6\*

646:3812

Manufactured

Purchased

Manufactured

No

105433 124089 1836 946 890 Each

Each

Loc Qty

0.0000

408.0000

Loc Code

\*\*

\*\*

13

A√3-3A

Gusset Bracket

Bolt

646.3813

Location Loc Qty Loc Code ST350 408 123831 108 124221 200 124552 100 Each 10.0000

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123831

13-03-20

Strut Bracket

Location ST139d 93252

Loc Qty 10 10 Loc Code

93252

 $\mathcal{Z}$ 

M128426 38 C

											DQA:	Date:	
NCR: Y	es	/ No				WORK ORDER NON-	CON	1FORM	MANCE / UPD	ATE	QA Closed:	Date:	,
Nork Orde	ŕ:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Part N	_					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root						ption of work order update	1	nitial	Actio		Sign &		
Cause	$\perp$	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
quip/Tooling perator Material etup other rocess upplier raining													
		· -					AUL	T CATE	GORY			1	
Landin		ear Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in	Crimped it n Strip in Bend	Tube		General  Bend  BOM/Route  Broken/Damaged  Burrs  Contamination  Countersink  Cut Too Short  Drill Holes  Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/Ui enance eled	nclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
}	-	Turning S				Finish	$\vdash$		Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

March-19-13 10:53:42 AM

Work Order ID: 98646

· Parent Item:

646.4001

Parent Item Name: AS350 Cable Cutter

\*98646\*

\*646 4001\*

ST316

**Start Date:** 3/19/13

Required Date: 4/02/13

Start Qty: 1.00

Required Qty: 1.00

MS21047-3

Purchased

No

Each 625.0000

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CCR264SS3-02

Purchased

Purchased

No

No

**Location** Loc Qty Loc Code 625 123268 75 123301 50 123522 500 Each 1,100.000

Each

\*\*

1,096.000

Loc Code

123 785

AN3-5A Bolt

> Location Loc Qty Loc Code FP001 32 122800 32 GA 120

117423 120 ST350 22 120187

122416 124561

ST512

22 922 122 800

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			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	•		
			QA Closed:	Date:	•

											QA Closed:	Date:	•
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	3
Part N	 No.					Rework Scrap	]		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR I	 No					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root					Descri	ption of work order update	Init	tial	Ad	ction	Sign &	1	
Cause		Date	Step	Qty	(	or Non-conformance	Chie	f Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data												!	
Equip/Tooling													
Operator													
Material	Ц											•	
Setup	Ш											i .	
Other												· :	
Process	Ш												
Supplier	Ш											d .	
Training	Ш												
Unapproved							<u> </u>					L!	
							AULT (	CATE	GORY				
Landi					_	General					1		<b>7</b> _
	—	ending			<u> </u>	Bend	$\mathbf{H}$	rain		<u> </u>	Ovalized		Pressure/Forced
	$oldsymbol{}$	entre No	t Concer	ntric to	o/s	BOM/Route	$\mathbf{H}$	ardwa		ļ	Over/Under		Temperature/Cure
		racks				Broken/Damaged	⊢	•	on Incomplete		Part Incorred	,	Weld
		rushed/0	Crimped		<u> </u>	Burrs	$\mathbf{H}$		ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	$oldsymbol{oldsymbol{ ext{H}}}$	uffs			_	Contamination	$\vdash$		nance	<u> </u>	Part Moved		
	$\mathbf{H}$	eat Trea			<u> </u>	Countersink		lislabe 		<u> </u>	Positioned W		T <sub>out</sub> .
	—	rspection		Tube	<u> </u>	Cut Too Short	$\vdash$	lisreac	I	L_	Power Loss/:	Surge	Other
	$\vdash$	ipples in			<u> </u>	Drill Holes	$\vdash$	ffset					
	${f eta}$	orque W		xtrusio	`  -	Drawing	$\vdash$		Calibration			1	
	——	urning Se			<u> </u>	Finish	$\vdash$		equence			,	
I	ı ıv	Vave/Tw	ist in Tub	e	1	Folio	I IO	utside	Dimensions			1	

March-19-13 10:53:42 AM

Work Order ID: 98646

\*98646\*

No

No

No

No

· Parent Item:

646.4001

\*646 4001\*

Parent Item Name: AS350 Cable Cutter

**Start Date:** 3/19/13

Required Date: 4/02/13

Start Qty: 1.00

Required Qty: 1.00

Strut Doubler

646.3715

MS27039-1-12

Purchased

Manufactured

Each 235.0000

0.0000

Loc Code

865.0000

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Screw

Purchased

Purchased

Manufactured No

Location

100993

Mezz

235 235 Each

Each

75

Each

Loc Qty

0.0000

M1250 83

MS24694-S54

646.3716

Gauge Bracket MS20426AD5-7

> Location Loc Qty Loc Code ST334 865 101340 865 Each 95.0000

01340

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Screw

Location Loc Oty Loc Code ST303 95 123900 20

124859

123900

												DQA:	Dat	te:	
NCR:	⁄es	/ No					WORK ORDER NON-C	100	VFORM	/ANCE / UP	PDATE				
						_		-				QA Closed:	Da	te:	•
Nork Orde	er:					ı	DISPOSITION				AGAINST DE	EPARTMENT	/PROCESS		,
Part N	•						Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR I	No.						Work Order Update	]		Large Fab	Composite		Supplier		
Root			*		Desc	rip	otion of work order update	П	nitial	Ac	ction	Sign &	1		
Cause		Date	Step	Qty	i	O	r Non-conformance	Ch	ief Eng	Desc	cription	Date	Verificatio	n	QC Inspector
oc/Data quip/Tooling perator Material etup Other rocess															in this pain
upplier													1		
raining < Inapproved				1								:	1		· · · · · · · · ·
парргочец		l	<u> </u>	l	L		F	AUL	T CATE	GORY		1			
Landi	ng (	Gear					General								
Carrar		Bending			<u> </u>		Bend		Grain		F	Ovalized	·		Pressure/Forced
		Centre No	ot Concer	ntric to	0/5		BOM/Route Broken/Damaged	$\vdash$	Hardwa		-	Over/Under Part Incorre	,		Temperature/Cure Weld
		Cracks Crushed/0	Crimpod		ŀ		Burrs	-	4	on Incomplete ions Incomplete/	/Unclear	Part Lost/Mi	1	┢	Wrong Stock Pulled
		Cuffs	crimpeu				Contamination	$\vdash$	Mainte	-	Officieal	Part Moved	351118	_	Wrong Stock I dired
	$\vdash$	Heat Trea	t				Countersink		Mislabe		<u> </u>	Positioned V	Vrong		
	$\vdash$	Inspection		Tube	Ì		Cut Too Short	$\vdash$	Misread			Power Loss/			Other The Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of the Control of
	$\vdash$	Ripples in	•		ļ		Drill Holes		Offset		<b>L</b>		· ·	_	
	$\vdash$	Torque W		extrusio	n þ		Drawing		4	Calibration					
	<u> </u>	Turning S			ľ		Finish		1	anuanca			(		

Outside Dimensions

Wave/Twist in Tube

Folio

March-19-13 10:53:42 AM

Work Order ID: 98646

646.4001

Parent Item Name: AS350 Cable Cutter

· Parent Item:

MS27039-1-21

\*98646\* \*646 4001\*

Location

115935

124326

93171

ST306

ST506

Location

st510

**Start Date:** 3/19/13

Required Date: 4/02/13

Start Qty: 1.00

Required Qty: 1.00

JB

Purchased

No

Each 387.0000

Loc Code

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MS27039-1-20

Purchased

No

300 124326 300

Each 500.0000

Loc Qty

87

87

\*\*

Screw

MS27039-1-19

Purchased

No

Loc Qty Loc Code 500 500 Each 1,102.000

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115935

Location Loc Qty Loc Code ST306 102 122814 2 123522 100 ST506 1000 124326 1000 Each 10.0000

646.3717

Manufactured

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Location Loc Oty Loc Code ST139A 10

10

93171

									DQA	:Date:	
NCR: Yes	/ No				WORK ORDER NON-C	CONFORI	MANCE / UP	PDATE	QA Closed	: Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	T/PROCESS	
Work Order.					Rework	1	Skid-tube	Crosstube	]	Water Jet	Engineering
Part No.					Scrap	]	Machining	Small Fab	Pro	od. Eng. Coor.	Quality
					Use-as-is	Therr	moforming	Finishing	Rec/Sto	ore/Packaging	Other
NCR No.					Work Order Update	]	Large Fab	Composite	J	Supplier	
Root		T	<u> </u>	Descri	tion of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspec
Doc/Data					-						
Equip/Tooling		l									

QC Inspector

### Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bend Grain Ovalized Bending Temperature/Cure Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Part Moved Cuffs Maintenance Contamination Mislabeled Positioned Wrong Heat Treat Countersink Other Power Loss/Surge Inspection Strip in Tube **Cut Too Short** Misread Drill Holes Offset Ripples in Bend Out of Calibration Drawing Torque Waves in Extrusion Out of Sequence Turning Sequence Finish Folio Outside Dimensions Wave/Twist in Tube

Operator Material Setup Other Process Supplier

March-19-13 10:53:42 AM

Work Order ID: 98646

Parent Item:

646.4001

Parent Item Name: AS350 Cable Cutter

\*98646\*

\*646 4001\*

Location

ST139B

93289

**Start Date:** 3/19/13

Required Date: 4/02/13

Start Qty: 1.00

Required Qty: 1.00

646.3718

Manufactured

Manufactured

No

Each

0.0000

20.0000

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MS27039-1-10

Purchased

No

Loc Qty Loc Code 20

Each

20 Each 359.0000

3-03-20

Screw

Location Loc Qty Loc Code GA 100 120449 100 ST305 101 122815 124859 100 ST308 18 123522 18 ST506 140 124326 140

124326

NCR:	Yes	/	No

DQA:

Date:

NCR:	⁄es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE	QA Closed:	Date	; ;
Vork Orde	er:					DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
Part I	•					Rework Scrap Use-as-is		r	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No.					Work Order Update	]		Large Fab	Composite	, Rec/stor	Supplier	Other
Root					Descri	iption of work order update	T	Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data													
uip/Tooling													
perator													
laterial												İ	
etup													
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rocess												1 1 1 1 1 1 1 1 1	
upplier												1	
raining							1						
napproved													
						F	AUL	T CATE	GORY			1	
Landi	ng (	Gear				General		_			_	i	
		Bending				Bend		Grain			Ovalized	L.	Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	it	Weld
		Crushed/0	Crimped			Burrs		instruct	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	j		Power Loss/	Surge	Other
		Ripples in				Drill Holes	Г	Offset			_	_	
		Torque W	aves in E	xtrusio	n	Drawing		Out of C	Calibration			-	
		Turning S				Finish		Out of S	Sequence			1	
		Wave/Tw				Folio		Outside	Dimensions			1	

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

March-19-13 10:53:42 AM

Work Order ID: 98646

· Parent Item:

, 00.0

646.4001

Parent Item Name: AS350 Cable Cutter

\*98646\* \*646 4001\*

**Start Date:** 3/19/13

Required Date: 4/02/13

Start Qty: 1.00

Required Qty: 1.00

\*AN3-11A\*-1

Purchased

No

Each 792.0000

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<u>C8</u>

13-03-2

			Location	Loc Qty	Loc Code		Sia
			ST351	192			
			110865	42			107-08
			123525	150			123525
			ST512	600			
			115457	100			
-			123352 123759	200 300			<del></del>
600.0990	Purchased	No	123739	Each	0.0000		
*600-0990*) Magnabond 6398 Part A (One 4 oz can)	ruichaseu	140		Each	0.0000	**	M125057 (SM-
600.0991	Purchased	No		Each	0.0000		( 5km)
*600 0991* Magnabond 6398 Part B (One 4 oz can)						**	M125057 a 3mi)
600.1012	Purchased	No		Each	0.0000		15.0
5 <b>*600-1012</b> * Sealant (One 6 oz Semkit)						**	m126057 (5H)
600.0129	Purchased	No		Each	0.0000		<u></u>
*600 0129*						**	M/2603/
/ 600.1013 1x qu' smb	Purchased	No		Each	0.0000		C5 / 5m
> *600-1013*	1 4.0.4454				0.000	**	M126164 5M

NCR:	Yes .	/	No

NCR: Y	es	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE	(	DQA: QA Closed:	Dat		
Mark Orda	÷.					DISPOSITION				AGAINST I	DEP	ARTMENT	/PROCESS		
Work Orde Part N NCR N	ο.					Rework Skid-tube Crosstub Scrap Machining Small Fa Use-as-is Thermoforming Finishir			Crosstube Small Fab Finishing Composite	b Prod. Eng. Coor. g Rec/Store/Packaging				Engineering Quality Other	
Root					Descr	iption of work order update		Initial	Ac	tion	T	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Desc	ription		Date	Verification		QC Inspector
oc/Data quip/Tooling perator faterial etup other rocess upplier														¥ **	
napproved				<u> </u>											
• • • •		•				1	FAU	LT CATE	GUKY						
Landir	ig G	Bending			Г	General Bend		Grain		F		Ovalized	Г	□ <sub>Pr</sub>	essure/Forced
			ot Conce	ntric to (	<sub>o/s</sub>  -	BOM/Route	-	Hardwa	ıre		_	Over/Under	tolerance		emperature/Cure
İ	Centre Not Concentric to O/S Cracks			Broken/Damaged		-1	ion Incomplete	<u> </u>	_	Part Incorre	· -	_	eld		
	Crushed/Crimped			Burrs		-4 `	ions Incomplete/	'Unclear		Part Lost/Mi	issing	$\exists_{w}$	rong Stock Pulled		
				Contamination		Mainte	·	Ī		Part Moved	· •				
				Countersink		Mislabe	eled			Positioned V	Vrong _				
		Inspection	n Strip in	Tube		Cut Too Short		Misread	d			Power Loss/	Surge [	01	ther
		Ripples in	Bend			Drill Holes		Offset				· .	1		
		Torque W	/aves in E	Extrusior	۱ [	Drawing		Out of 0	Calibration		_		1		· · ·
		Turning S	equence	!		Finish		Out of 9	Sequence		_				
		Wave/Tw	ist in Tul	be		Folio	Folio Outside Dimensions								

March-19-13 10:53:42 AM

Work Order ID: 98646

· Parent Item:

646.4001

Parent Item Name: AS350 Cable Cutter

\*98646\* \*646 4001\*

**Start Date:** 3/19/13

Required Date: 4/02/13

Start Qty: 1.00

Required Qty: 1.00

646.3910

Manufactured

Each 90.0000

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Page 12

646.3911

646.3913

Manufactured

90 93238 90 Each

Loc Qty

Loc Qty

29

29

Each

Each

30

29.0000

Loc Code

Manufactured

Location ST139d

Location

ST139d

93362

Loc Code

91.0000

Loc Code

93362

Manufactured No Location ST139d

93423

Loc Qty 91 91

30.0000

Location Loc Oty Loc Code ST139d 30

93160

93160

NCR-	Yes	1	No

DQA:

Date:

NCR: Ye	es / No				WORK ORDER NON-CONFORMANCE / UPDATE						:	
					_					QA Closed:	Date	:
Nork Ordei	ŕ:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	, ,
				<del></del>	Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part No	0.				Scrap	1	ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	]	Therm	noforming	Finishing	Rec/Sto	e/Packaging	Other
NCR N	o				Work Order Update	]		Large Fab	Composite		Supplier	
		<b>T</b>	·	<del></del>		<u> </u>						
Root	1	1			ption of work order update		nitial		ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
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quip/Tooling	4										1	
perator	-	ļ										
Material	-					1					•	
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upplier	_										<b>:</b>   .	
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Inapproved	<u>i</u>	_i	<u> </u>			 ΕΔΙΙΙ΄	T CATE	GORY				
Landin	g Gear				General	AUL	CAIL	3011				
Г	Bending				Bend	П	Grain		Г	Ovalized		Pressure/Forced
<b>-</b>	<b>→</b>	lot Conce	ntric to		BOM/Route		Hardwa	re	-	Over/Under	tolerance	Temperature/Cure
<b> </b>	Cracks			~~~   <del>-</del>	Broken/Damaged	$\vdash$		on Incomplete	<u> </u>	Part Incorred	<del>-</del>	Weld
-		/Crimped		<u> </u>	Burrs	-		ions Incomplete/	/Unclear	Part Lost/Mi	-	Wrong Stock Pulled
-	Cuffs	, <b>,</b>		<del> </del>	Contamination		Mainte		-	Part Moved	. · · <u>-</u>	_
<u> </u>	Heat Tre	at			Countersink	$\vdash$	Mislabe			Positioned V	'	
ŀ		on Strip in	Tube	<u> </u>	Cut Too Short	$\vdash$	Misread			Power Loss/		Other
+	Ripples i			<u> </u>	Drill Holes	$\vdash$	Offset		<u> </u>			
ŀ	<b>—</b>	Naves in I	Extrusio	,	Drawing	$\vdash$		Calibration			1	
f	<b>⊣</b> `	Sequence		<u> </u>	Finish	-		Sequence		···	1	
ļ.		wist in Tu		<u> </u>	Folio			Dimensions				

March-19-13 10:53:42 AM

Work Order ID: 98646

646.4001

Parent Item Name: AS350 Cable Cutter

· Parent Item:

AN3-12A

\*98646\*

\*646 4001\*

**Start Date: 3/19/13** 

Required Date: 4/02/13

Start Qty: 1.00

Required Qty: 1.00

Purchased

No

Each

151.0000

Location Loc Qty Loc Code GA 6 122407 6 ST351 45 114536 123352 44 ST512 100 123759 100 Each

MS27039-1-16

Purchased

No

106.0000

\*\*

Location Loc Oty Loc Code ST306 106 121444 6 122993 100

122993

March-19-13 10:53:42 AM

**Shop Packet Print** 

Page 13

												DQA:	Da	te:	
NCR: Y	'es	/ No					WORK ORDER NON-O	WORK ORDER NON-CONFORMANCE / UPDATE						+a:	
						_			r			QA Closed:	Da	te:	•
Nork Orde	, i					ı	DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
WOIK OIGE	٠٠.			<del></del>		١	Rework	1		Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	lo.						Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Н	Quality
							Use-as-is	1		noforming	Finishing	<b>-</b>	e/Packaging	П	Other
NCR N	lo.						Work Order Update			Large Fab	Composite		Supplier		
Root					Desc	_	tion of work order update	,	Initial	Act		Sign &			
Cause	_	Date	Step	Qty		0	r Non-conformance	Ch	nief Eng	Descr	iption	Date	Verificatio	n	QC Inspector
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Landi	ng (	Gear					General		_		<u> </u>	_			
•		Bending					Bend		Grain			Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s [		BOM/Route		Hardwa	re		Over/Under	tolerance	Ш	Temperature/Cure
		Cracks					Broken/Damaged		Inspect	on Incomplete		Part Incorred	ct c	$\vdash$	Weld
		Crushed/	Crimped		L		Burrs		Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	,		Wrong Stock Pulled
Cuffs				Contamination	_	Mainte	nance	<u> </u>	Part Moved						
	_	Heat Trea					Countersink		Mislabe		<u> </u>	Positioned V	1	_	<b>i</b>
		Inspection	-	Tube			Cut Too Short	L	Misread	1	L	Power Loss/	Surge		Other
:	<u> </u>	Ripples in					Drill Holes	$\vdash$	Offset						
	_	Torque W			n		Drawing	<u> </u>	4	Calibration					
Turning Sequence				Finish	Out of Sequence				•						

Outside Dimensions

Wave/Twist in Tube

Folio

_		
	ENGINEERING CHANGE NOTICE NO. 03079 SHEET 1	JF 1
APICAL	DWG NO. 646,4000 REV: A PREPARED N.CAP DATE: 03/21/11 EFFEC	T ON DWG . 🖾 UNINC.
INDUSTRIES, INC.	DWG TITLE: AS350 CABLE CUTTERS KIT	
	APPROVED BY: ENGRY Sano MFG David Barbon OC Mounts of NEXT E	JRDER
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE	REASON: CREATED FIXED AND CCK WITHOUT FIXED PROVISIONS KIT	
SHEET 1,	REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF   REF	
DOCUMENTS EFFECTED:	D: CHANGE CATEGORY DER REVIEW REQUIRE  MAJOR MINOR D YES MINOR	.υ μ.

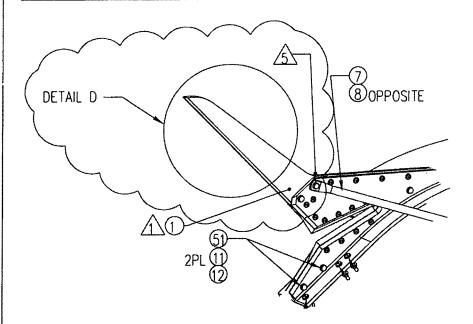
98646

	ENGINEERING CHANGE NOTICL	N□. 03046	SHEET 1 OF 1
APTOAL	DWG NO. 646.4000 REV: A	PREPARED  J. JACKSON DATE: 01/2	24/11   EFFECT ON DWG □ INC. \(\text{\text{UNINC.}}\)
INDUSTRIES, INC.	DWG TITLE: AS350 CABLE CUT	TERS KIT	·
	APPROVED BY: ENGR Brance MFG Da	vit Parla Oc Mount Jengus	EFF: NEXT ORDER
TRANSACTION CODES (TC): A-ADD C-CREATE D-DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DELVIS DEL	REASON: ADDED GPS MOUNT KIT, F/N ADDED NOTE/7.	65. REVISED DRAWING VIEWS	
R-REVISE D-DELETE	I ADDED NOTE [//].		

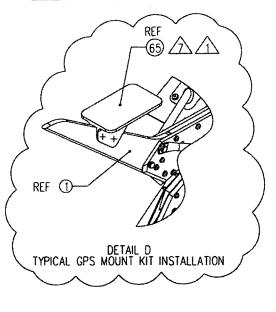
# SHEET 1, ZONE B1 IS:

AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ONTO F/N 1.

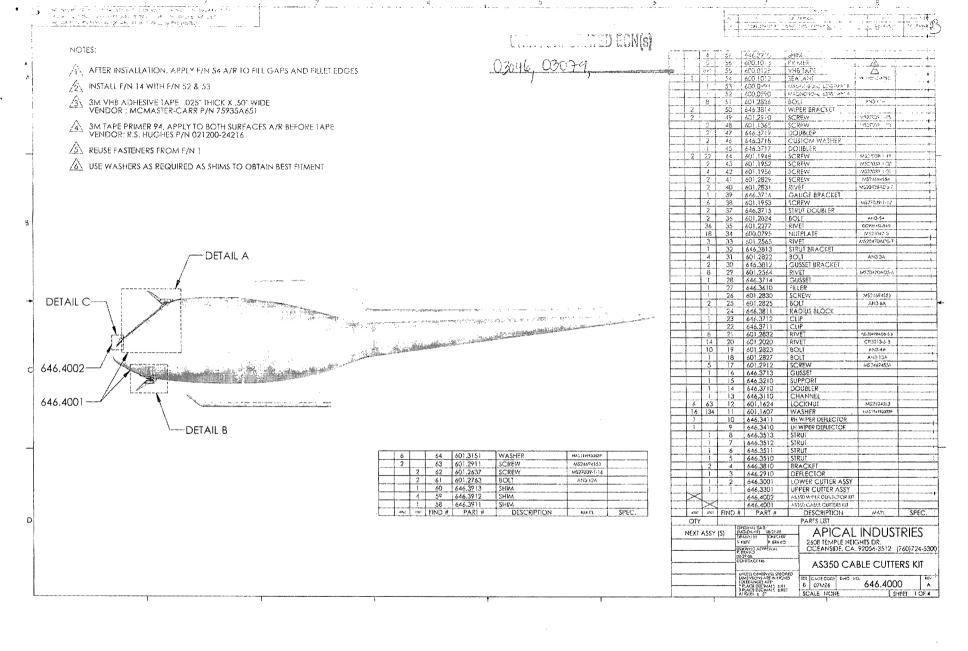
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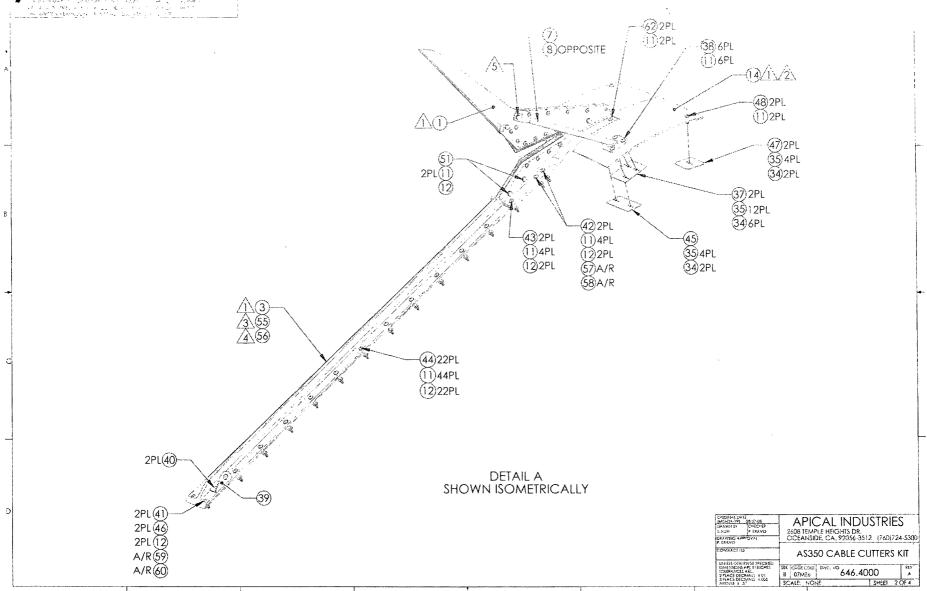


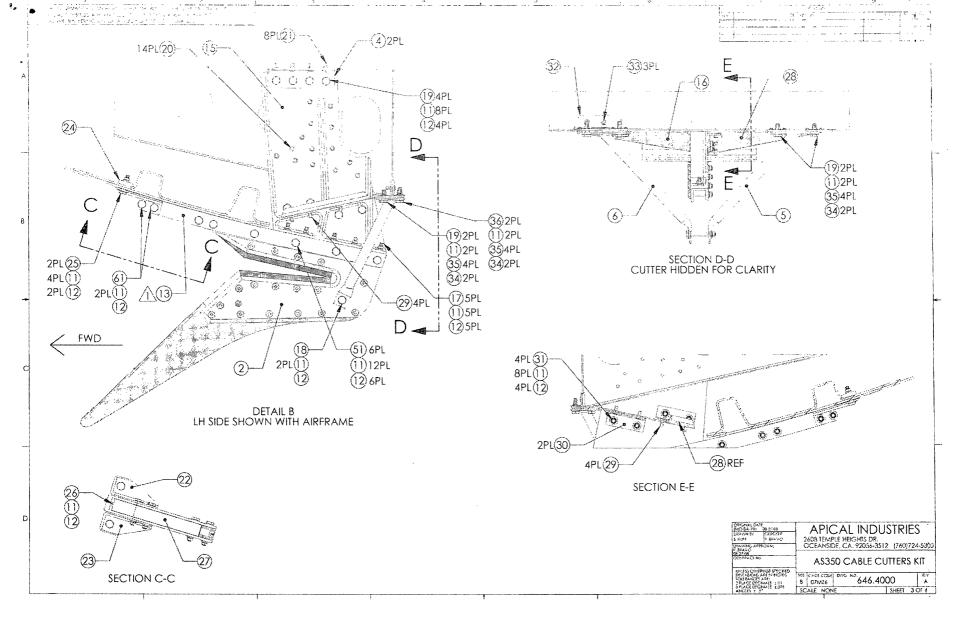
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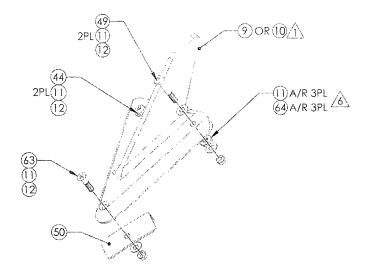


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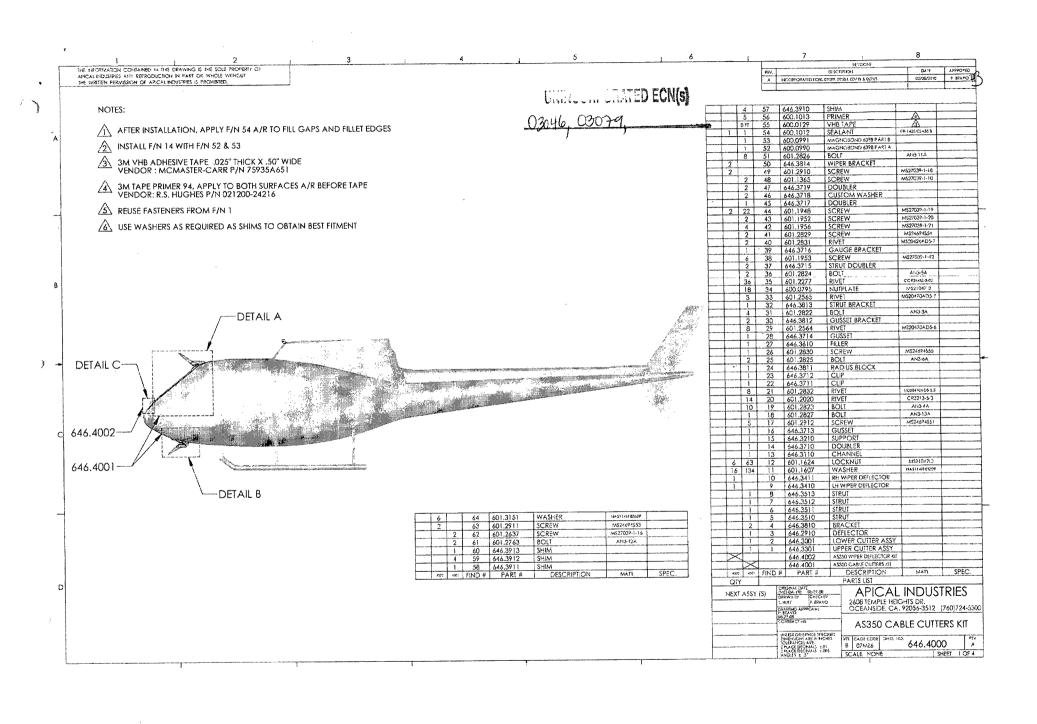


DETAIL C LH SHOWN EXPLODED RH OPPOSITE

	8-07-48	APIC	CALINDUS	TRIFS
	CHECKEP II BRAYO	2608 TEMP	LE HEIGHTS DR.	
PANDA AFPE	36%;	OCEANSE	DE, CA. 92056-3512	(750)724-5300
COLUBACI No.		AS35	O CABLE CUT	TERS KIT
UNITES OTHERS DIMENSIONS AS TOLEPANCES A	RE BAI DATCHES	901 CAG: COO! B 075476	<sup>646,400</sup>	0 %
SPLACE DECM		SCALE NON		SHEET 4 Of A

D

SHEET 1 JF 1 ENGINEERING CHANGE NOTICE NO. 03079 EFFECT ON DWG DATE: 03/21/11 PREPARED N.CAP APICAL DWG NO. 646.4000 REV: A ☐ INC. 🖾 UNINC. DWG TITLE: AS350 CABLE CUTTERS KIT INDUSTRIES, INC. NEXT ORDER Mounte APPROVED BY REASON: CREATED FIXED AND CCK WITHOUT FIXED PROVISIONS KIT TRANSACTION CODES (TC) A-ADD C-CREATE D-DELETE R-REVISE MICHOG 6398 PART B ANG-BA KS27839-1-18 HS27439-1-16 SHEET 1, BOM, IS: MS27039-1-19 NS27039-1-29 NS27039-1-21 1624694334 HS28426AUS-7 MS27639-1-12 HS21947-3 NS28478ARS-7 MC2-35 NS28476AZE-6 MS24694335 - NO-6A CR3213-5-3 - MG-44 -MO-DA M2469423 DOUBLER HS204813 -PERMIT SCREV-HS24694353 RH VIPER BEFLECTUR 0 LH VIPER BEFLECTUR
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1. Approving National Aviation 3. Form Tracking Number: Page 1 of 3 Authority/Country: **AUTHORIZED RELEASE CERTIFICATE** MG13-078 **FAA/UNITED STATES** FAA Form 8130-3, AIRWORTHINESS APFROVAL TAG 4. Organization Name and Address: 5. Work Order/Contract/Invoice Number: Apical Industries, Inc. Shipper # 12443 2608 Temple Heights Drive **PQ1886NM** P.O. # AS350-CCK/PO19331 Oceanside, CA 92056 Item: 7. Description: Part Number: Eligibility: \* 10. Quantity: 11. Serial/Batch Number: Status/Work: 1. **Upper Cutter Assy** 646.3301 N/A 16 119640-3 New 2. **Lower Cutter Assy** 646,3001 20 119737-1 3. Deflector 646.2910 17 119572-1 Doubler 646.3710 -113434-1-Strut Doubler 646.3715 2 114916-7 6. Gusset 646.3714 113434-3 **Doubler** 646.3715 113434-4 Shim 646,3911 113080-5 Gusset 646.3713 113434-2 10. **Bracket** 646.3810 113012-4 11. Support 646.3210 114263-3 12. **Gusset Bracket** 646.3812 113579-1 13. Strut Bracket 646,3813 112165-3 14. Shim 646.3910 26 114916-5 15. Shim 646.3912 26 114916-6 Channel 646.3110 118257-8 13. Remarks: **EXPORT AIRWORTHINESS APPROVAL** A. These parts listed in Block 7. are subcomponents of a PMA Article B. Bilaterial Agreement - None C. Items are being shipped to Dart Aerospace Ltd. in Hawkesbury, ON, Canada. D. Last item entered..... 14. Certifies the items identified above were manufactured in conformity to: Approved design data and are in condition for safe operation Non-approved design data specified in Block 13. 15. Authorized Signature: 16. Approved/Authorization No.: **DMIR 606259-NM** 17. Name (Typed or Printed): 18. Date (m/d/y): Lisa Mansfield March 18, 2013 User/Installer Responsibilities It is important to understand that the existence of this document alone does not automatically constitute authority to install the part/component/assembly. Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different that the airworthiness authority of the country specified in Block 1, it is essential that the user/installer ensures that his/her airworthiness accepts parts/components/assemblies from the airworthiness authority of the country specified in Block 1. Statements in Blocks 14 and 19 do not constitute installation certification. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the

\*Installer must cross-check eligibility with applicable technical data.

NSN: 0052-00-012-9005

user/installer before the aircraft may be flown.

FAA Form 8130-3(6-01)

1. Approving National Aviation 3. Form Tracking Number: Page 2 of 3 **Authority/Country:** AUTHORIZED RELEASE CERTIFICATE MG13-078 **FAA/UNITED STATES** FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG 4. Organization Name and Address: 5. Work Order/Contract/Invoice Number: Apical Industries, Inc. Shipper # 12443 2608 Temple Heights Drive P.O. # AS350-CCK/V0 [ 9 3 3 ] PO1886NM Oceanside, CA 92056 6. Item: 7. **Description:** 8. Part Number: Eligibility: \* **Ouantity:** 11. Serial/Batch Number: 12. Status/Work: 17. Strut 646,3512 N/A 12 111971-3 New 18. Doubler 646.3719 24 117341-6 Strut 646:3510 -117341-2 20. Strut 646.3511 117341-3 21. Clip 646,3711 13 117341-1 22. Clip 646.3712 13 117341-4 23. **Custom Washer** 646,3718 27 117341-5 24. Gauge Bracket 646,3716 15 117953-1 25. Filler 646.3610 17 115914-2 26. Shim 646.3913 17 117953-2 27. Radius Block 646,3811 20 117651-1 28. Strut 646,3513 35 11971-1, 115105-1, 115741-3 29. Bolt 601.2825 192 107245-1, 119183-2 Bolt 601,2827 69 106824-1, 114455-1 31. Bolt 601.2763 206 41764-3, 46468-1 32. Screw 601.2830 149 41769-8, 107245-8 13. Remarks: EXPORT AIRWORTHINESS APPROVAL A. These parts listed in Block 7. are subcomponents of a PMA Article B. Bilaterial Agreement - None C. Items are being shipped to Dart Aerospace Ltd. in Hawkesbury, ON, Canada. D. Last item entered..... 14. Certifies the items identified above were manufactured in conformity to: Approved design data and are in condition for safe operation Non-approved design data specified in Block 13. 15. Authorized-Signature: 16. Approved/Authorization No.: **DMIR 606259-NM** 17. Name (Typed or Printed): 18. Date (m/d/y): Lisa Mansfield March 18, 2013 User/Installer Responsibilities It is important to understand that the existence of this document alone does not automatically constitute authority to install the part/component/assembly. Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different that the airworthiness authority of the country specified in Block 1, it is essential that the user/installer ensures that his/her airworthiness accepts parts/components/assemblies from the airworthiness authority of the country specified in Block 1. Statements in Blocks 14 and 19 do not constitute installation certification. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the

\*Installer must cross-check eligibility with applicable technical data.

NSN: 0052-00-012-9005

user/installer before the aircraft may be flown.

FAA Form 8130-3(6-01)

1. Approving National Aviation 3. Form Tracking Number: Page 3 of 3 Authority/Country: **AUTHORIZED RELEASE CERTIFICATE** MG13-078 **FAA/UNITED STATES** FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG 4: Organization Name and Address: 5. Work Order/Contract/Invoice Number: Apical Industries, Inc. Shipper # 12443 2608 Temple Heights Drive P.O. # AS350-CCK / DD 19331 PO1886NM Oceanside, CA 92056 Item: 7. Description: Part Number: Eligibility: \* 10. Quantity: Serial/Batch Number: 12. Status/Work: 11. 33. Rivet 601,2831 N/A 604 76557-10, 107245-7, 115478-4 New 34. LH Wiper Deflector 646.3410 15 110777-1 35. AS350 Wiper deflector Kit 646,4002 031, 032, 033, 034 36. RH Wiper Deflector 646.3411 16 118480-1 37. Wiper Bracket 646,3814 45 107056-3, 116390-2 13. Remarks: **EXPORT AIRWORTHINESS APPROVAL** A. These parts listed in Block 7. are subcomponents of a PMA Article B. Bilaterial Agreement - None C. Items are being shipped to Dart Aerospace Ltd. in Hawkesbury, ON, Canada. D. Last item entered..... 14. Certifies the items identified above were manufactured in conformity to: Approved design data and are in condition for safe operation Non-approved design data specified in Block 13. 15. Authorized Signature; 16. Approved/Authorization No.:

17. Name (Typed or Printed):

**DMIR 606259-NM** 

18. Date (m/d/y):

Lisa Mansfield March 18, 2013

User/Installer Responsibilities

It is important to understand that the existence of this document alone does not automatically constitute authority to install the part/component/assembly.

Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different that the airworthiness authority of the country specified in Block 1, it is essential that the user/installer ensures that his/her airworthiness accepts parts/components/assemblies from the airworthiness authority of the country specified in Block 1.

Statements in Blocks 14 and 19 do not constitute installation certification. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.

### Work Order ID 98646

March-19-13 10:53:39 AM

Quality Control

\*98646\*

646.4001 \*N900040100\* • Item ID: Accept Setup Start Revision ID: Stop AS350 Cable Cutter Item Name: 3/19/13 Start Qty: 1.00 **Start Date:** Cust Item ID: Required Date: 4/02/13 Req'd Qty: 1.00 **Customer:** Reference: Run Start Date: 13-03-19 Tooling: Process Plan: MLJ Approvals: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Reject Set Up/ Tool ID Tool # Plan Accept Reject Insp. Description **Work Center ID** Code Qty **Qty** Number Stamp **Run Hours Draw Nbr Revision Nbr** 13-03-20 646.4000 Α 100 0.00 DOCUMENT CONTROL \*100\* DC 0.00 Memo Document Control Photocopy bluefile & type labels per PPP 646.4001 110 Pick Kit 0.00 \*110\* Packaging 0.00 Memo Packaging 120 QC4-100% Inspect kits for completeness 0.00 QC 0.00 Memo